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**ABSTRACT**

A method for forming a tool having a smooth surface finish is disclosed. The method involves the step of first rotating a plurality of tools within an inner vessel at high speed relative to the outer vessel with a first abrasive. The first abrasive is then removed and a second abrasive is added to the vessel. The inner vessel is then rotated, again at high speed, with the second abrasive. The resulting tools have reduced surface anomalies.